

# Work Order ID 86193

**\*86193\***

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Item ID: D2171

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Clamp

Stop **\*NS2\***

Start Date: 22/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/22

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2171	Rev D					84			
100	PURCHASING	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
304.063"	Dwg Rev: <u>B</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

B12-7-5

B12-7-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86193

\*86193\*

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Start Date: 22/06/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

\*130\*

Small Fab

Brake NC

Memo

0.00

Brake NC

1 - remove press and machine marking as necessary

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

counts  
34

SB  
12/07/09

counts  
34

W/O:		WORK ORDER CHANGES					
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Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Clamp

Start Date: 22/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: US7

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

(34)

12/7/10sf

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

CK 12/7/10

ME 12-07-10

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 86193

\*86193\*

Parent Item: D2171

\*D2171\*

Parent Item Name: Clamp

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	1.5746	0.0258	0.543158	1.		

\*M304S16GA\*

304/316 Sheet .063

\*\*

B12-7-5

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

34

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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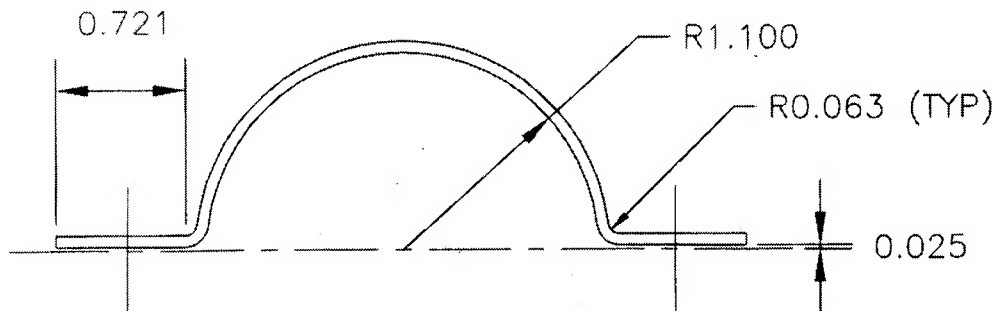
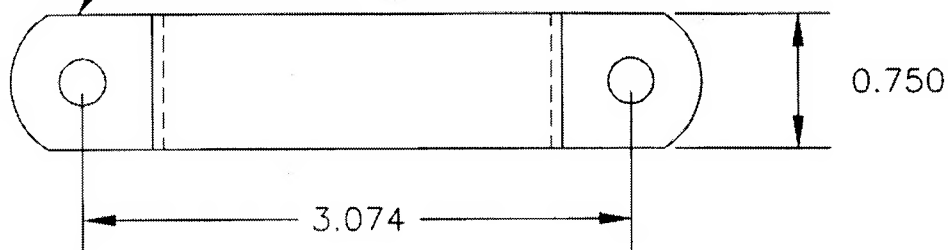
**NOTE:** Date & initial all entries



DESIGN BW	DRAWN BY DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED KE	DRAWING NO. D2171	REV. D SHEET 1 OF 1
DATE 99.03.08	TITLE CLAMP		SCALE 1:1
B	96.01.29	REDRAWN	
C	97.05.14	RADIUS CHANGED, CUSHION ADDED	
D	99.03.08	REMOVE CUSHION (TSR A890) 4.158 WAS 4.888	

RELEASED  
99.03.11 KE

PUNCH ENDS PER SPEC  
CONTROL DRAWING D2727



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86193 M2  
12/06/22

MATERIAL: 304/316 SS 0.063 THICK  
FLAT LENGTH: 4.968 END-END  
4.158 HOLE-HOLE



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